

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75970

75970

Page 2

November-02-11 10:45:28 AM

Item ID: D3262-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Canister Assembly
 Start Date: 02/11/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 16/11/2011 Req'd Qty: 2.00 ***2*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	Chemical Conversion Coat per QSI005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--

130

HandFinish

Hand Finishing

Memo

0.00

2X ✓ M-11/12/06

140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

140

Powdercoat

Powder Coating

Memo

****Ensure to mask threads ****

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

0.00

8-30
3200 F
9-00

2X ✓ M-11/12/07

150	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

150

QC

Quality Control

Memo

0.00

2 BR 11-12-7

M119480

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Work Order ID 75970***75970***

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Item ID: D3262-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Canister Assembly
Start Date: 02/11/2011 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 16/11/2011 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: ST 144	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

2x **SP 11-12-07**

11/2/8 **11-12-07**

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November-02-11 10:45:32 AM

75970

D3262-043

Required Qty: 2.00

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3262-1		Manufactured	No			100	Each	0.0000	1	2			
D3262-1					B75196	(2)			**			11.12.06	
Tube													
D3262-5		Manufactured	No			100	Each	5.0000	2	4			
D3262-5									**			11.12.06	
Cap													
					<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>					
					LG002	B77064	5			3			
					74724		5			1			

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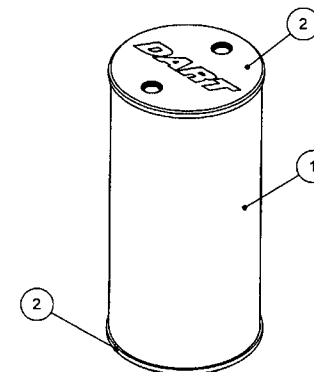
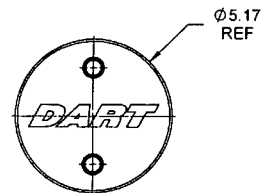
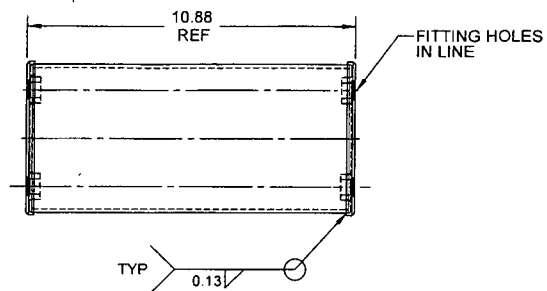
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75970 H.C.J
1111/02



D3262-041 CANISTER ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 2.51 lbs
 - 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

ITEM	QTY	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

RELEASED
2010-05-07
N/A

E	0.25 WAS 0.45 (ZNC7-4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7-5); ADD DIMENSION (ZN B1-4, D1-5, B1-5)	RF	10.05.03
D	ADD D3262-043/-5 (ZN B5-2; B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4; C2-4) PER CAR 09-004	RF	09.12.30
C	Ø5.165 WAS Ø5.190	RF	06.08.31
B	ADD PRESSURE TESTING OPTION	MB	05.02.14
A	NEW ISSUE	RF	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. E
CHECKED	RF	D3262	SHEET 1 OF 5
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	FUEL PURGE CANISTER	NTS
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DATE	10.05.03		

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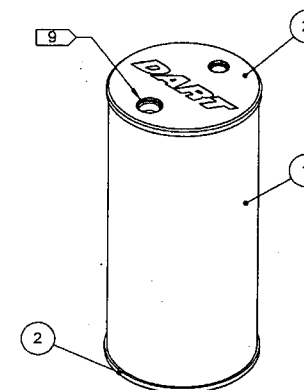
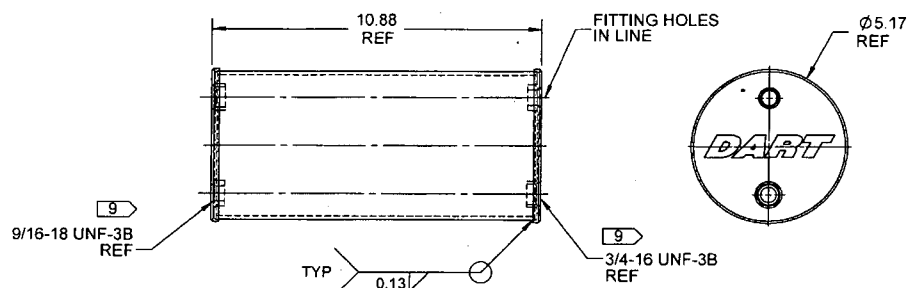
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ITEM	QTY	P/N	DESCRIPTION
	X	D3262-043	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-5	CAP



D3262-043 CANISTER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.50 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

RELEASED
2010-05-07
AM

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3262	SHEET 2 OF 5
APPROVED	RF	TITLE	SCALE
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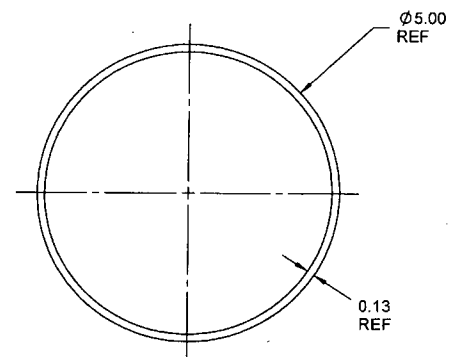
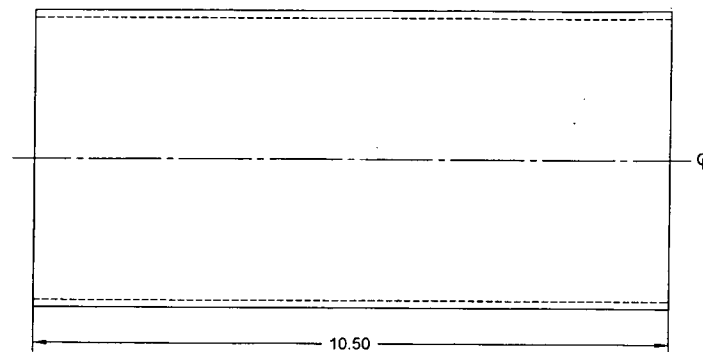
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75970



D3262-1 TUBE

RELEASED
2010-05-07
JW

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6T5.000W.125
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.96 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

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MFG. APPR.	<i>[Signature]</i>	D3262	SHEET 3 OF 5
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0.25

$\triangle E$

$\phi 0.875$

2 PL

B B1-4

R0.063
TYP

+0.010
 $\phi 5.005$
-0.000

0.070 x 45°
CHAMFER

0.13
TYP

0.080
TYP

Technical drawing of a circular part with two holes and a central logo. The drawing includes the following dimensions and specifications:

- DRILL THRU Ø0.516 (33/64 DRILL), TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879 2 PL**
- Ø5.165 REF**
- 1.63**
- 3.25 REF**
- B6-4**
- A**
- 6**
- DART**

Technical drawing of a mechanical part with dimensions and tolerances:

- Top edge: $0.696^{+0.007}_{-0.008}$ 2 PL
- Top fillet: $R0.03 \pm 0.01$
- Inner fillet: $R0.02^{+0.00}_{-0.01}$
- Top chamfer: 45°
- Inner chamfer: 30°
- Bottom edge: $0.091^{+0.007}_{-0.008}$ 2 PL
- Bottom width: 0.45
- Bottom corner: E

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. 1
MFG. APPR.	<i>[Signature]</i>	D3262	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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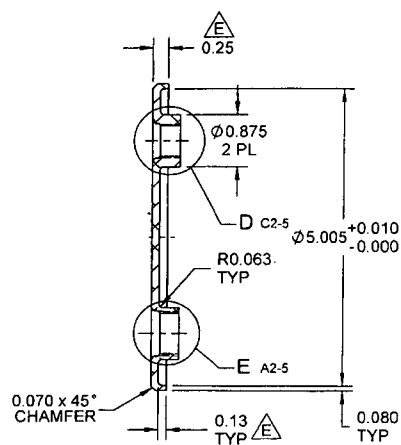
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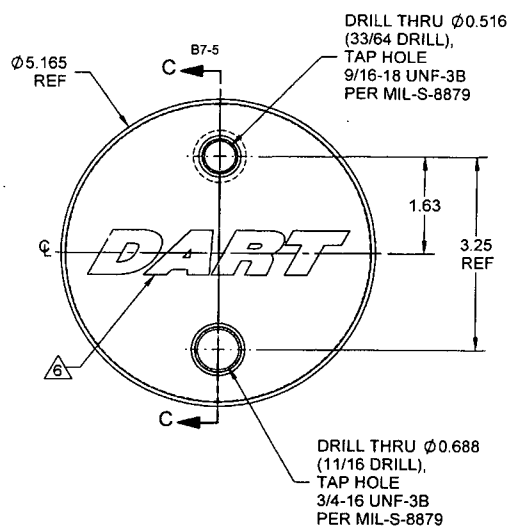
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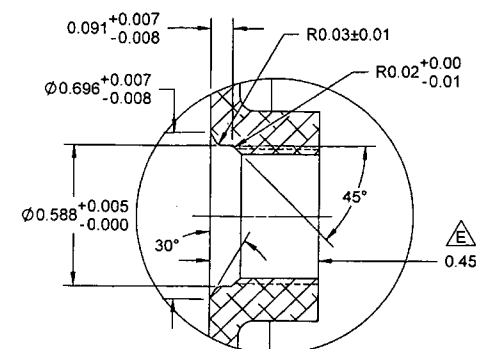
75970



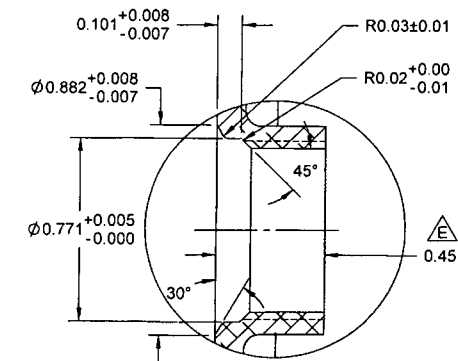
SECTION C-C D5-5



D3262-5 CAP



DETAIL D C7-5
SCALE 2X



DETAIL E B7-5
SCALE 2X

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.27 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

RELEASED
2010-05-07

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CHECKED	RF	DRAWING NO.	REV. E
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DE APPR.	RF	FUEL PURGE CANISTER	NTS
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